Date: User:

Thursday, 16/04/2009 1:43:02 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

: 47246 Job Number

Estimate Number

P.O. Number

This Issue : 16/04/2009 Prsht Rev.

: NC

First Issue **Previous Run**

: 46431

: 10175

: //

: MACHINED PARTS Type

Part Number

Drawing Name

: D2570 . D2570 REV B

: B

: BUSHING

Drawing Number

: N/A

Project Number Drawing Revision

Material **Due Date**

: 23/04/2009

Qty:

500 Um:

Each

Checked & Approved By

Comment

Written By

E 02.08.29

Re-format; Removed finishing; Material change K

est F 07.07.06 rev B dwg

EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0750

303 Round Bar 0.750



Comment: Qty.:

0.0810 f(s)/Unit Total:

40.4775 f(s)

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Batch *M///323*

2.0

THARDINGE DOSSAN

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA258

Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE





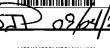
4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING RESOURCE #1



PACKAGING '



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Page 1

Form: rprocess

W/O:		W	ORK ORDER CHANG	ES							
DATE	STEP	PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•									
							<u>-</u>				
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	es N	lo DQ	A:	Date:		
Resolution:		esolution:							Date:		
NCR:			WORK ORE	DER NON-CONFORMA	NCE (N	CR)					
DATE	CTED	Description of NC	Corrective Action Secti			Verification			Approval Appro	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	}	ion C	Chief Eng	QC Inspector	
					:						
										:	
								:			
NOTE: D	ate & initio	al all entries								•	
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Date:

Thursday, 16/04/2009 1:43:02 PM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 47246

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE

mf 09-04-22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:

			WOTH OTHER								
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC inspector	
					•						
							Miles like .				
										:	
Part No	:		_PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _		
	Re	esolution:		Disposition:	QA	: N/C C	closed:	<u></u>	Date: _		

WORK ORDER CHANGES

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	0.750	Description of NC		Corrective Action Section B	Verification	Approval	Ammunud				
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
•											
NOTE: D	ate & initial	all ontrine		WW.				•			

DART AEROSPACE LTD	Work Order:	472410
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

	FIRST	Γ ARTICLE IN	ISPECTI	ON CHE	ECKLIST		
	X	First Artic	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
0.800	+/-0.010	~ 800					
0.060	+/-0.005	. OLO					
R0.010	+0.010/-0.000	2.015					
Ø0.425	+0.000/-0.002	. 4235					
Ø0.257	+0.006/-0.001	-358					
Ø0.750	+/-0.010	-750					
0.030 x 20°	+/-0.010	1625×Jo	•				
			-				
						-	
	-						
							
Measured by:	W//	Audited by:	DD	ζ	Prototype	Approval:	N/A
Date:	09/04/00	Date:	09/04	<i>[21</i>]		Date:	
Rev Date	Changé					Revised by	Approved

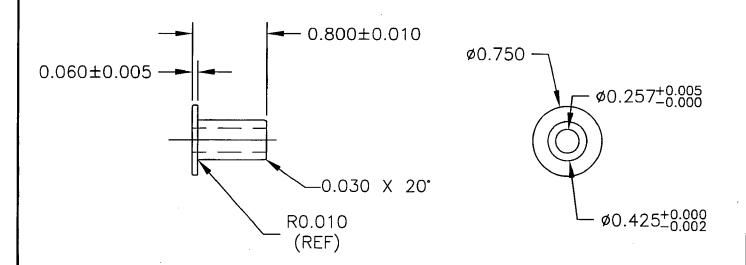
Rev	Date	Change	Revised by Approved
Α	03.12.08	New Issue	KJ/RF
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM 1/A
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD 🛠

W/O:	,		WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			the same		į					
										
			•							
Part No		<i></i> PAR #:								
	Re	esolution:	Disposition	1:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			,
DATE	STED	Description of NC			ction B		Verific	ation	Approval	Approval
·	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspecto	
-										
						•				

NOTE: Date & initial all entries



DESIGN DRAWN BY PH PH				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHEC	KED	APPROVED	DRAWING NO.	REV. B				
		#	H	D2570	SHEET 1 OF 1				
	DATE		· ·	TITLE	SCALE				
	07.0	04.17		BUSHING	1:1				
	Α		96.09.16	NEW ISSUE					
	В		07.04.17	UPDATE NOTES					



D2570 BUSHING

D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- ALL DIMENSIONS ARE INCHES 3)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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W/O:		WORK ORDER CHA	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #: Fault Category:	NCR:	Yes	No DQA	٨:	_ Date:				

Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Ammuoval					
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
					•						
								A			

NOTE: Date & initial all entries

Resolution: